

Date: Thursday, 19/04/2007 8:34:23 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CHAFING SHIELD
Job Number	: 31952		
Estimate Number	: 12815		
P.O. Number	: <i>N/A</i>	Part Number	: D3189 <i>1-1</i>
This Issue	: 19/04/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3189 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 31656	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 20/04/2007 Qty: 5 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est. A 07.04.04 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S25GA <i>256-A</i>	304/316 0.018 SHEET
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Comment: Qty.: 0.2205 sf(s)/Unit Total : 1.1025 sf(s)
 304/316 SS (020" Sheet
 (M304S25GA)
 Batch: *M102393*

MF 07-04-19

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut to size as per Dwg D3189

MF 07-04-19 (5)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr & Grind Rads as per Dwg D3189

MF 07-04-19

2-Roll as per Dwg D3189

MF 07-04-19

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SB 07/04/19 (5)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *[Signature]*

07/04/20 (5)

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Process Sheet

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Drawing Name: CHAFING SHIELD

Job Number: 31952

Part Number: D31893

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

19 07/04/2007 (5)

Job Completion



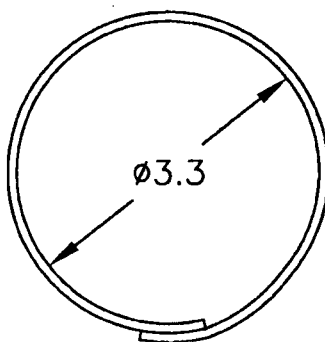
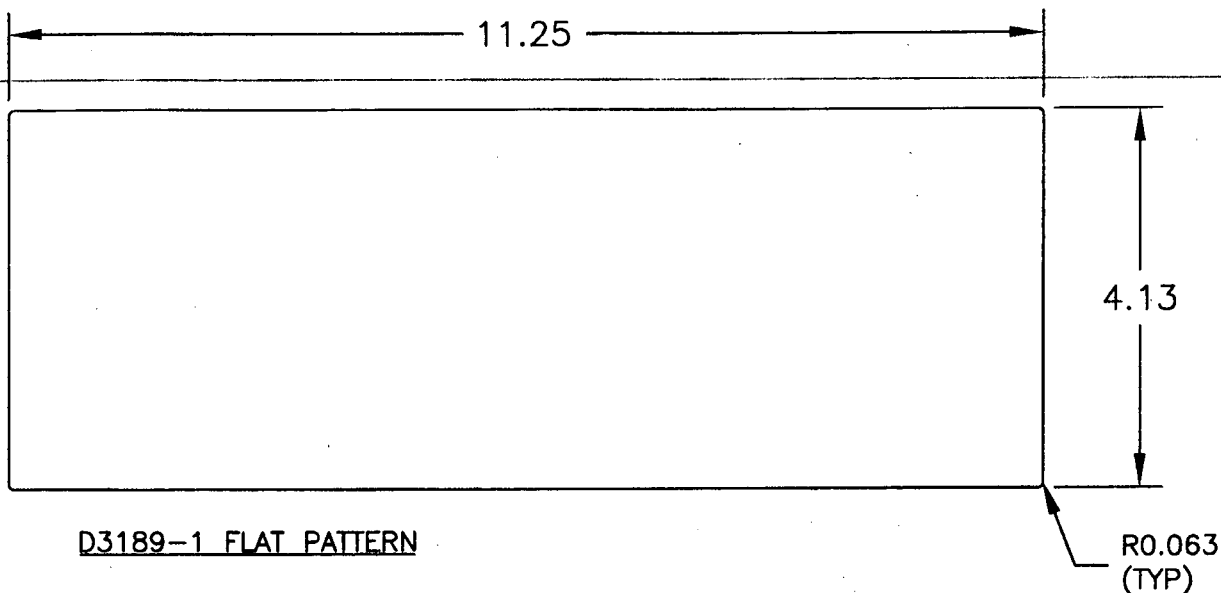
10 07-24-20



DESIGN qp	DRAWN BY qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3189	REV. B SHEET 1 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08	NEW ISSUE	
B	07.01.05	ADD -3	

RELEASED

07.03.27 [Signature]



D3189-1 ROLLING DETAIL
NOT TO SCALE

01031952

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES


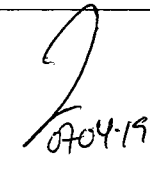
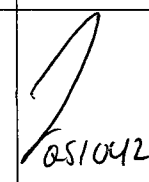
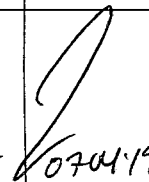
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070419	20	Material was incorrect, due to W/O. W/O calls 26 GA on top; 25 GA on the dwg.	 051042	Material used is 0.015," and is acceptable this time.	MF. 07-04- 19.	 070419	 051042	 070419.

NOTE: Date & initial all entries